

Friday 25/07/2008 10:01:35 AM  
Linda Lacelle

## Process Sheet

*split 08/08/25*

|  |                                       |
|--|---------------------------------------|
| Customer : CC-DAR01 Dart Aerospace Ltd.    | Drawing Name : D206-558-043           |
| Part Number : 40756 <i>2</i>               |                                       |
| Estimate Number : 10804                    |                                       |
| Part Number :                              | Part Number : D206558043              |
| Issue : 25/07/2008 S.O. No. :              | Drawing Number : ECN08-504            |
| Revised Rev. : NC                          | Project Number :                      |
| Part Issue : 1/1 Type : SMALL /MED FAB     | Drawing Revision :                    |
| Previous Run : 40748                       | Material :                            |
| Drawn By : <i>[Signature]</i>              | Due Date : 01/08/2008 Qty: 7 Um: Each |
| Checked & Approved By : <i>[Signature]</i> |                                       |
| Comment :                                  |                                       |

Original Product

Number



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

3 x D206-558-043 B39284

4 x D206-558-043 B39518

*4x FF 08-07-31*

*(4)*

2.0

D206558043

Dual Cargo Mirror Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Single Cargo Mirror Assembly

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

*W 2x D2011-101*

*B 43235*

DISCARD HARDWARE

*FF 08-07-31*

*(4)*

*EP 08/11/26*

*FF 08-07-31*

*(4)*

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-043

Job Number: 40756

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 12.2502 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W049)

Identify as D2066

Deburr and Polish

Note: Punch 1 end only at this time

Batch M 108324

SP 08/08/20

(6)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall

Slide on parts D2052, D2055, D2056, D2054 as per Dwg D206-558

Note orientation of belcrank and order of parts.

Punch other end to length (28.62") as per Dwg D2066

Use template DT8054

SP 08/08/20

(6)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Flatten the ends on Hydraulic press using DT8545

Bend per Dwg D2066 using template D2066T1

Deburr

Drill 3/16" Dia holes per D2066T1 template and Dwg D2066

Deburr holes

Assemble remaining parts as per Dwg D206-558

USING NEW HARDWARE:

SP 08/08/20

(6)

FF 08/08/25

(6)

7.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer M 108558 24.0000

FF 08/08/25

(6)



Friday, 25/07/2008 10:01:35 AM  
Linda Lacelle

# Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-043

Job Number: 40756

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~14.0000~~ Each(s)  
Nut *m 108747* *12.0000*

*FF 08/08/25 (6)*

9.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~14.0000~~ Each(s)  
Screw *M108161* *12.0000*

*FF 08/08/25 (6)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/12/03*

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS  
ENSURE ORIGINAL KIT IN BOX

*S 08/12/03*

*(10)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-558-043  
USING NEW B/N  
NEW LABELS REQUIRED AT CHG 08  
ADD PAPERWORK DSI 9416 TO KIT

*0508.12.03*

*(1008)*

*for 1x per ECU & 548*  
*08.11.26*

Location: *42*

PPP Rev: *A*

*8/12/03*

*(12)*

*54*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/12/04*

Job Completion



*11 08.12.04*

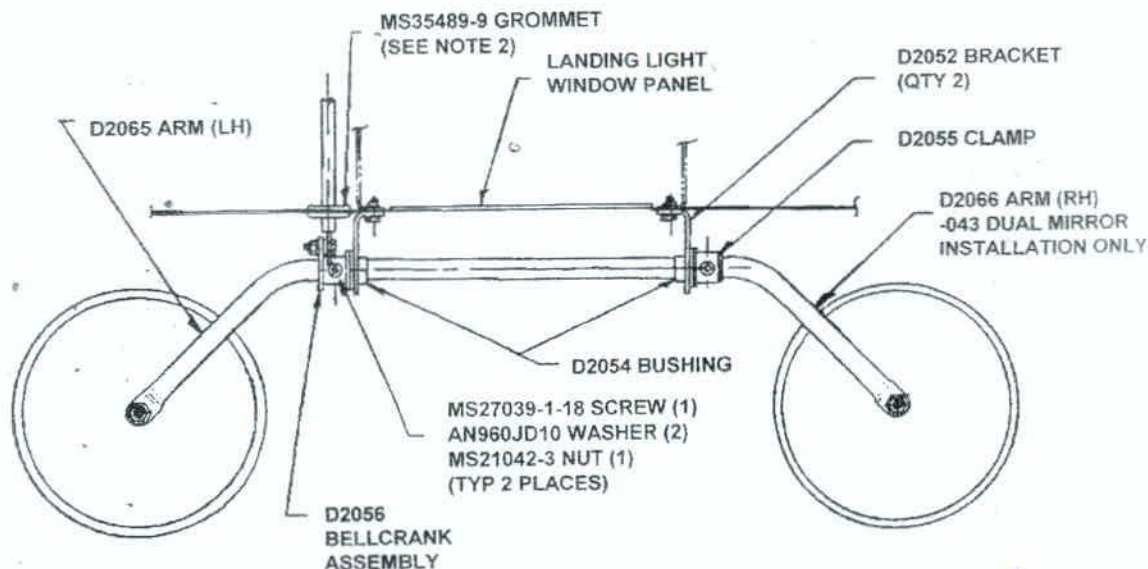


Figure 25.2 - View A: Looking Aft.  
(D206-558-043 Mirror Shown)

*Mo 40756*

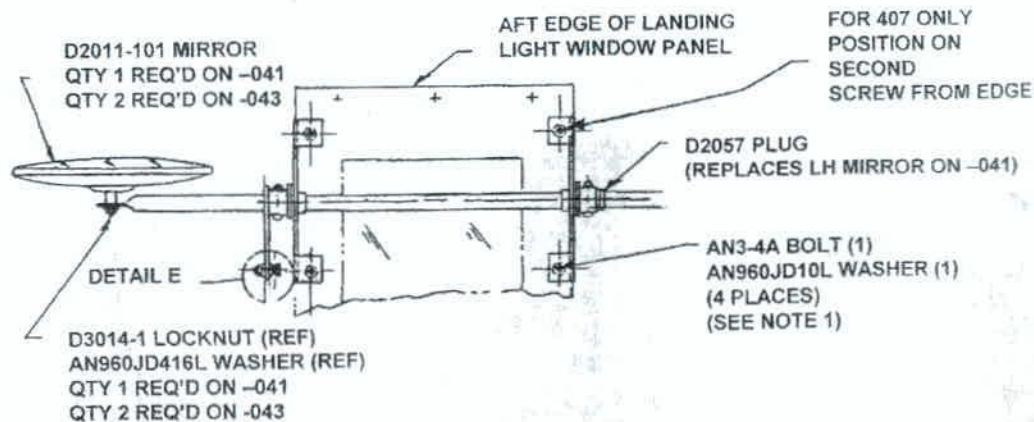


Figure 25.3 - View C: Looking Down on Mirror Installation  
(D206-558-041 Mirror Shown)

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**25-00-00**